



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D205-634-141**  
**Job Sheet 176918**



Part No: D205-634-141

Job Qty: 1 ea

Part Name: Replacement Skidtube with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/3/18

Job Tracking No:

Due Date: 5/29/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: D205-634 REV.II D2580 REV.H IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 90    | Start up Operation | 1 Ea  | 5/29/18    | 5/29/18  | 0.00      | 0.00    | Start Up Skidtubes-1  |           | M66            |
| 110   | Skidtubes          | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.65    | Skidtubes-2           |           | M66            |
| 120   | CNC Bend Skidtubes | 1 pcs | 5/29/18    | 5/29/18  | 0.52      | 0.65    | CNC Bend Skidtube     |           | M66            |
| 130   | Skidtubes          | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.65    | Skidtubes-2           |           | M66            |
| 140   | QC                 | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.00    | QC5                   |           | AR             |
| 150   | Skidtubes          | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.65    | Skidtubes-2           |           | M66            |
| 160   | QC                 | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.00    | QC10                  |           | DAS 38         |
| 170   | QC                 | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.00    | QC5                   |           | 38             |
| 180   | HandFinish         | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.04    | HandFinish2           |           | RET 18-05-09   |
| 190   | Powdercoat         | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.25    | Powdercoat1           |           | BR 18-5-10     |
| 200   | QC                 | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.00    | QC3                   |           | DEB 18-05-10   |
| 210   | HandFinish         | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.83    | HandFinish4           |           | BLB 18-05-10   |
| 220   | QC                 | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.00    | QC5                   |           | 38             |
| 225   | DC                 | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.00    | DC                    |           | 18-5-11        |
| 230   | Packaging          | 1 pcs | 5/29/18    | 5/29/18  | 0.00      | 0.00    | Packaging3-1          |           | 18-5-11        |
| 240   | QC21-FG            | 1 Ea  | 5/29/18    | 5/29/18  | 0.00      | 0.00    | QC21                  |           | 21 MAY 11 2018 |

Part Op 110 - 1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL 3.630" HOLES  
Descriptions: USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)

120 - 1-Bend as per program D2580.C on CNC Bender and Folio FT 16

130 - 1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.

150 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 038611 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR

180 - And realodine tube as per QSI 005

190 - START TIME: 10:05 CUT. 300° FINISH: 10:35

210 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 1158787 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# M138761

220 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

225 - Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG004

230 - Identify and pack for shipping as per PPPD205-634-141 Location : FG084



| Job BOM       |                         |               |                       |                       |
|---------------|-------------------------|---------------|-----------------------|-----------------------|
| Part / Item   | Component Name          | Quantity      | Operation             | Container             |
| D2580-1       | 205 Bent Tube           | 1 Ea (1 ea)   | 90-Start up Operation | S061525               |
| D2576-3       | Step (Machining Detail) | 1 Ea (1 ea)   | 150-Skidtubes         | S069014               |
| D4202-1       | Spacer                  | 24 Ea (24 ea) | 150-Skidtubes         | S054571               |
| AN3-5A        | Bolt                    | 2 Ea (2 ea)   | 210-HandFinish        | S041106-1             |
| AN4-45A       | Bolt                    | 8 Ea (8 ea)   | 210-HandFinish        | S017093               |
| D2570         | Bushing                 | 16 Ea (16 ea) | 210-HandFinish        | S068697-1             |
| D2594-1       | Plug                    | 8 Ea (8 ea)   | 210-HandFinish        | S054786               |
| D2594-3       | O-Ring                  | 8 Ea (8 ea)   | 210-HandFinish        | 7xS04997 / 1xS04997 5 |
| D2855         | Cap                     | 1 Ea (1 ea)   | 210-HandFinish        | F151613               |
| D4406-041     | Fwd Wearplate Assembly  | 1 Ea (1 ea)   | 210-HandFinish        | S040999               |
| D4406-043     | Aft Wearplate Assembly  | 1 Ea (1 ea)   | 210-HandFinish        | S057634               |
| MS21042-4     | Nut                     | 8 Ea (8 ea)   | 210-HandFinish        | S038763               |
| NAS1149D0332J | Washer                  | 2 Ea (2 ea)   | 210-HandFinish        | S020606               |

| Job Allocations       |                |          |           |           |
|-----------------------|----------------|----------|-----------|-----------|
| Operation             | Component Part | Required | Inventory | Allocated |
| 90-Start up Operation | D2580-1        | 1        | 2         | 0         |
| 150-Skidtubes         | D2576-3        | 1        | 1         | 0         |
|                       | D4202-1        | 24       | 569       | 0         |
| 210-HandFinish        | AN3-5A         | 2        | 365       | 0         |
|                       | AN4-45A        | 8        | 58        | 0         |
|                       | D2570          | 16       | 154       | 0         |
|                       | D2594-1        | 8        | 640       | 0         |
|                       | D2594-3        | 8        | 909       | 0         |
|                       | D2855          | 1        | 106       | 0         |
|                       | D4406-041      | 1        | 2         | 0         |
|                       | D4406-043      | 1        | 3         | 0         |
|                       | MS21042-4      | 8        | 131       | 0         |
|                       | NAS1149D0332J  | 2        | 2,823     | 0         |

| Part Specifications                |  |  |  |  |
|------------------------------------|--|--|--|--|
| Specifications could not be found. |  |  |  |  |

Plex 5/3/18 9:08 AM dart.lacelle.linda

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Container No: S068073



Part: D205-634-141

Job No: 176918

Serial No/Batch: S068073

Revision: H/I

Inspector:

Date: 05/03/18

003150

| ITEM | QTY<br>-041 | QTY<br>-045 | QTY<br>-047 | QTY<br>-049 | PART NUMBER                                                               | DESCRIPTION        |
|------|-------------|-------------|-------------|-------------|---------------------------------------------------------------------------|--------------------|
| 1    | X           |             |             |             | D2580-041                                                                 | SKIDTUBE ASSEMBLY  |
| 2    |             | X           |             |             | D2580-045                                                                 | SKIDTUBE ASSEMBLY  |
| 3    |             |             | X           |             | D2580-047                                                                 | SKIDTUBE ASSEMBLY  |
| 4    |             |             |             | X           | D2580-049                                                                 | SKIDTUBE ASSEMBLY  |
| 20   | 1           | 1           | 1           | 1           | D2500-1-190                                                               | EXTRUSION          |
| 21   |             |             | 16          | 16          | D2570                                                                     | BUSHING            |
| 22   | 1           | 1           | 1           | 1           | D2576-3                                                                   | STEP               |
| 23   |             | 4           |             |             | D2579                                                                     | SPACER             |
| 24   | 16          | 16          | 8           | 8           | D2594-1                                                                   | PLUG               |
| 25   | 16          | 16          | 8           | 8           | D2594-3                                                                   | O-RING             |
| 26   | 1           | 1           | 1           | 1           | D2596                                                                     | 205 WEB            |
| 27   | 1           | 1           | 1           | 1           | D2555                                                                     | AFT CAP            |
| 28   | 1           | 1           |             |             | D3584-5                                                                   | WEARSHOE           |
| 29   | 1           | 1           |             |             | D3584-6                                                                   | WEARSHOE           |
| 30   | 1           | 1           |             |             | D3584-11                                                                  | WEARSHOE           |
| 31   | 1           | 1           |             |             | D3584-13                                                                  | WEARSHOE           |
| 32   | 20          | 20          | 24          | 24          | D4202-1                                                                   | SPACER             |
| 33   |             |             | 1           |             | D4406-041                                                                 | WEARPLATE ASSEMBLY |
| 34   |             |             | 1           |             | D4406-043                                                                 | WEARPLATE ASSEMBLY |
| 35   |             |             |             | 1           | D5061-1                                                                   | FWD WEARPLATE      |
| 36   |             |             |             | 1           | D5061-3                                                                   | AFT WEARPLATE      |
| 50   | 50          | 50          |             |             | AL57-1032-130<br>or AKS7-1032-130<br>or AKS4-1032-130<br>or AELS-1032-130 | INSERT             |
| 51   | 50          | 50          |             |             | AN3C4A                                                                    | BOLT               |
| 52   | 2           | 2           | 2           | 2           | AN3-5A                                                                    | BOLT               |
| 53   |             |             | 8           | 8           | AN4-45A                                                                   | BOLT               |
| 54   | 50          | 50          |             |             | NAS1149C0332R                                                             | WASHER (AN980C10L) |
| 55   | 2           | 2           | 2           | 2           | NAS1149D0332J                                                             | WASHER (AN980J10L) |
| 56   |             |             | 8           | 8           | MS21042-4                                                                 | NUT (OR MS21042L4) |

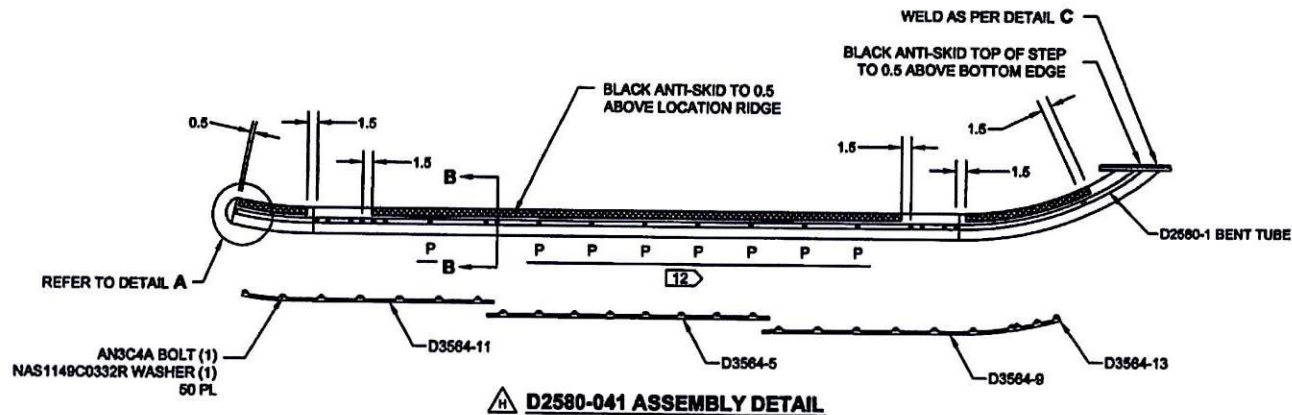
# GENERAL NOTES:

- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.6.1) PER DART QSI 005 4.3  
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 33.7 lbs  
D2580-045 = 33.7 lbs  
D2580-047 = 45.1 lbs  
D2580-049 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE DT8217 & DT8837 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL 20.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2555 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

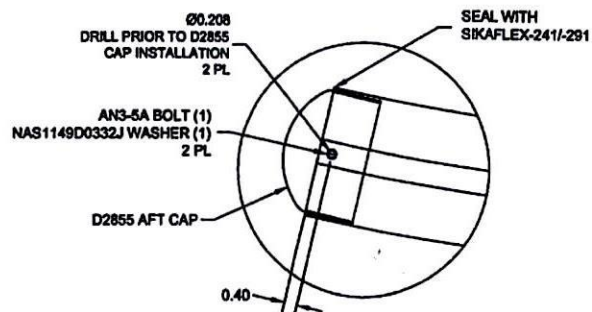
|            |                                                                                                                                                           |                                                                                                                                                                                                                                                                         |              |
|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| H          | SHEET : PL DELETE D3586-1/5-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS                                 | SAD                                                                                                                                                                                                                                                                     | 17.06.09     |
| G          | ADDED -048, -047 WEIGHT UPDATED PER DSI 9596                                                                                                              | AJS                                                                                                                                                                                                                                                                     | 14.04.09     |
| F          | INCORPORATE DEO D2580-E-1 PER PAR12-218                                                                                                                   | DC                                                                                                                                                                                                                                                                      | 13.06.20     |
| E          | ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8837 WAS TD2577-205 (ZN C4-1) | RF                                                                                                                                                                                                                                                                      | 11.06.21     |
| D          | CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183                                                                                               | PH                                                                                                                                                                                                                                                                      | 07.04.06     |
| C          | REDRAWN, INCLUDED DEO 9094/ 9097                                                                                                                          | CP                                                                                                                                                                                                                                                                      | 06.06.26     |
| B          | AS MANUFACTURED                                                                                                                                           | DS                                                                                                                                                                                                                                                                      | 06.12.02     |
| A          | NEW ISSUE                                                                                                                                                 | DS                                                                                                                                                                                                                                                                      | 06.06.16     |
| REV.       | DESCRIPTION                                                                                                                                               | BY                                                                                                                                                                                                                                                                      | DATE         |
| DESIGN     | DS                                                                                                                                                        | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                       |              |
| DRAWN      | SAD                                                                                                                                                       |                                                                                                                                                                                                                                                                         |              |
| CHECKED    | <i>[Signature]</i>                                                                                                                                        | DRAWING NO.                                                                                                                                                                                                                                                             | REV. H       |
| MFG. APPR. | <i>[Signature]</i>                                                                                                                                        | D2580                                                                                                                                                                                                                                                                   | SHEET 1 OF 9 |
| APPROVED   | <i>[Signature]</i>                                                                                                                                        | TITLE                                                                                                                                                                                                                                                                   | SCALE        |
| DE APPR.   | <i>[Signature]</i>                                                                                                                                        | 205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                   | NTS          |
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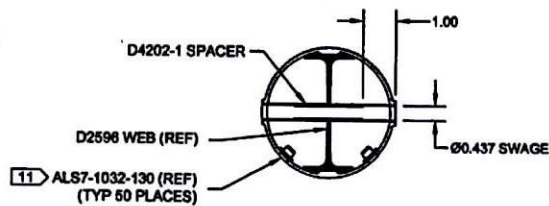
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**DETAIL A**  
SCALE 5X

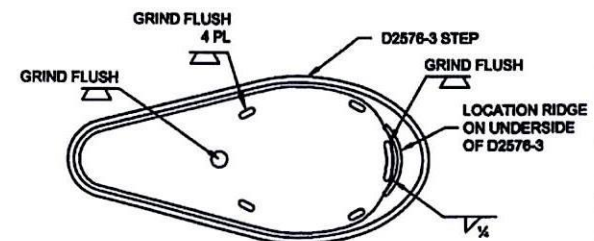


**SECTION B-B**  
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. INSERT D4202-1 SPACER (20 PLACES)  
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002  
3. TRIM / GRIND FLUSH PER QSI 002

**DETAIL C**  
SCALE 5X

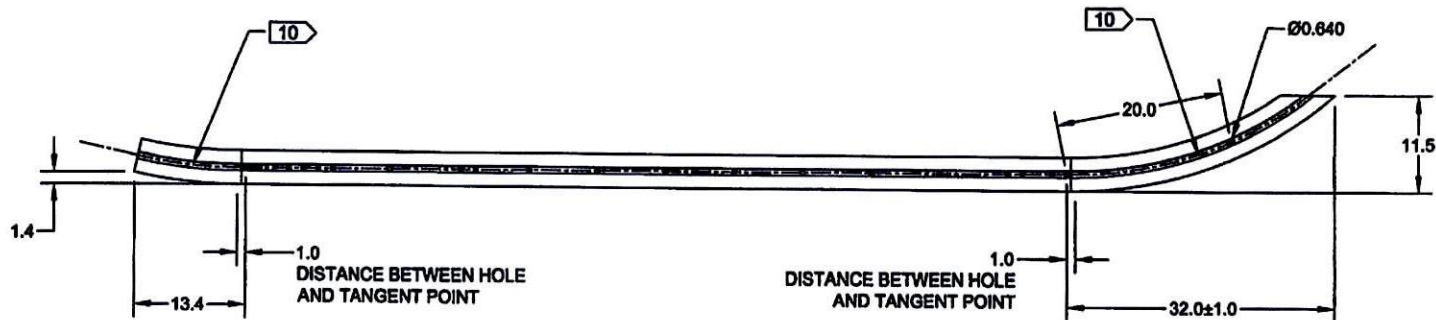


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| MFG. APPR. | <i>[Signature]</i> | D2580                                                                                                                                                                                                                                             | SHEET 2 OF 9 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                             | SCALE        |
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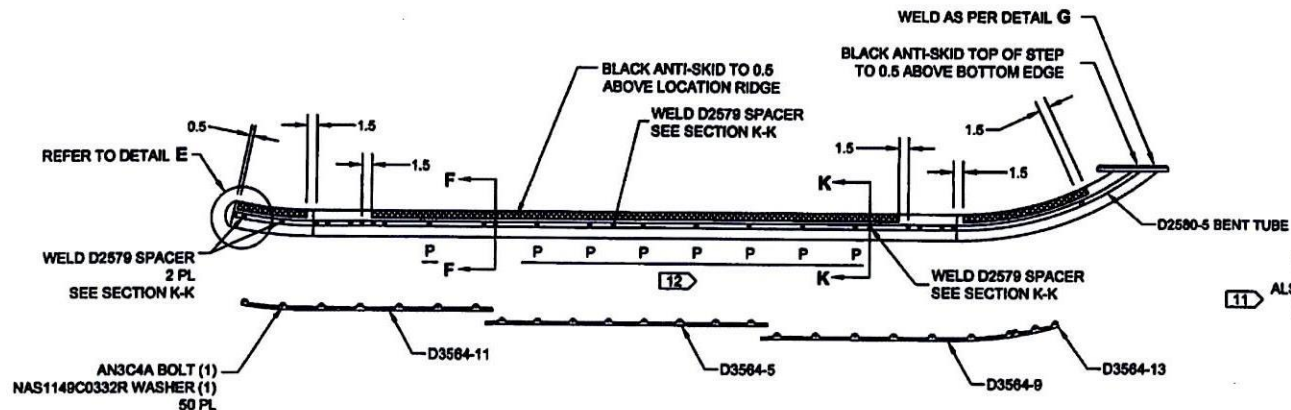




**D2580-1 BENT TUBE**  
(MAKE FROM D2580-101 TUBE)

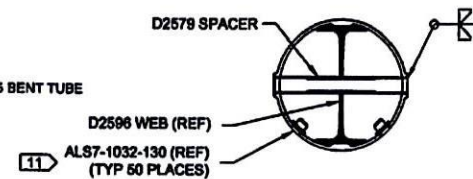
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| CHECKED                                                                                                                                                                                                                                                    | <i>[Signature]</i> | DRAWING NO.                            | REV. H       |
| MFG. APPR.                                                                                                                                                                                                                                                 | <i>[Signature]</i> | D2580                                  | SHEET 3 OF 9 |
| APPROVED                                                                                                                                                                                                                                                   | <i>[Signature]</i> | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                                                   | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                  | NTS          |
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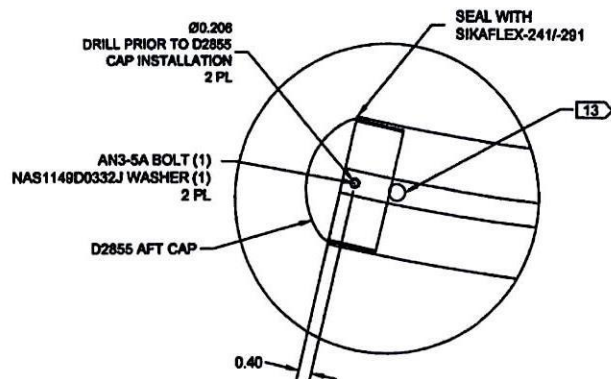
**D2580-045 ASSEMBLY DETAIL**

**SECTION K-K  
SCALE 5X**



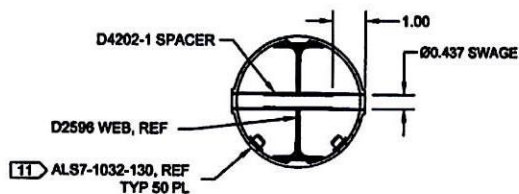
AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (4 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. DO NOT C'BORE

**DETAIL E  
SCALE 5X**



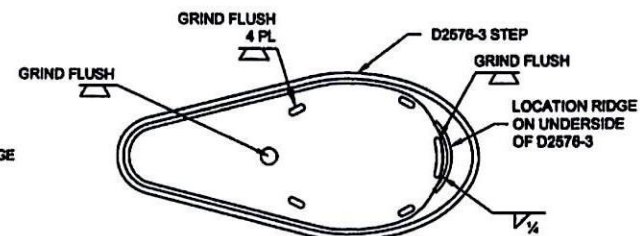
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**SECTION F-F  
SCALE 5X**

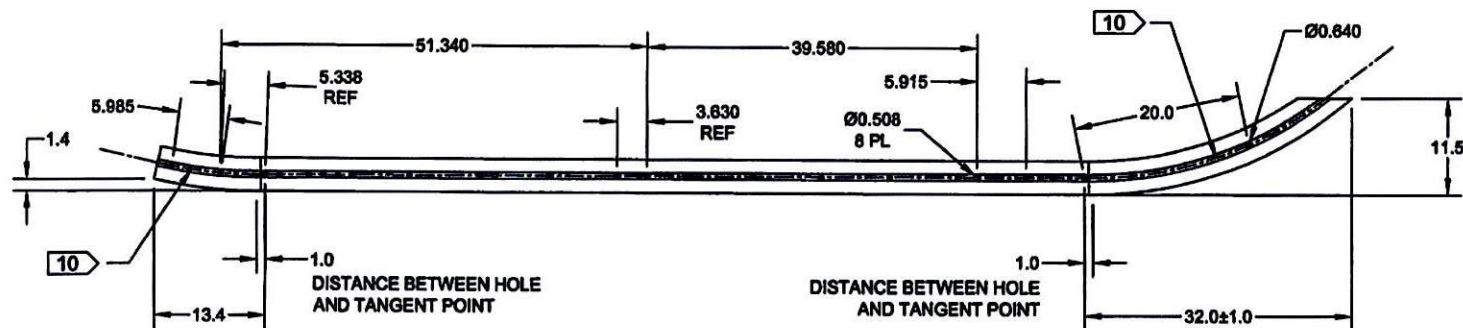


AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. INSERT D4202-1 SPACER (20 PLACES)  
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002  
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G  
SCALE 5X**



|            |                    |                                                                                                                                                                                                                                                                                                   |              |
|------------|--------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DS                 | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                         |              |
| DRAWN      | SAD                | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                       |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.                                                                                                                                                                                                                                                                                       | REV. H       |
| MFG. APPR. | <i>[Signature]</i> | D2580                                                                                                                                                                                                                                                                                             | SHEET 4 OF 8 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                             | SCALE        |
| DE APPR.   | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                             | NTS          |
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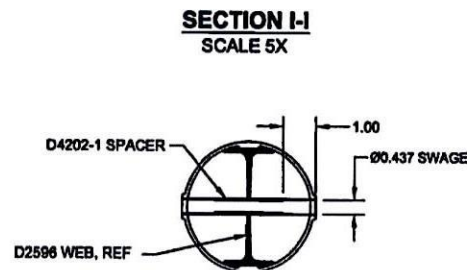
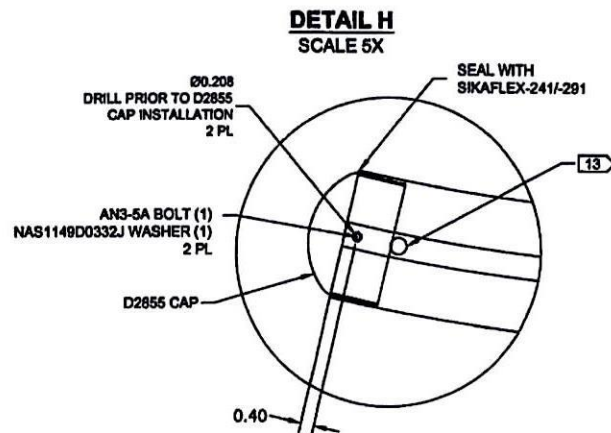
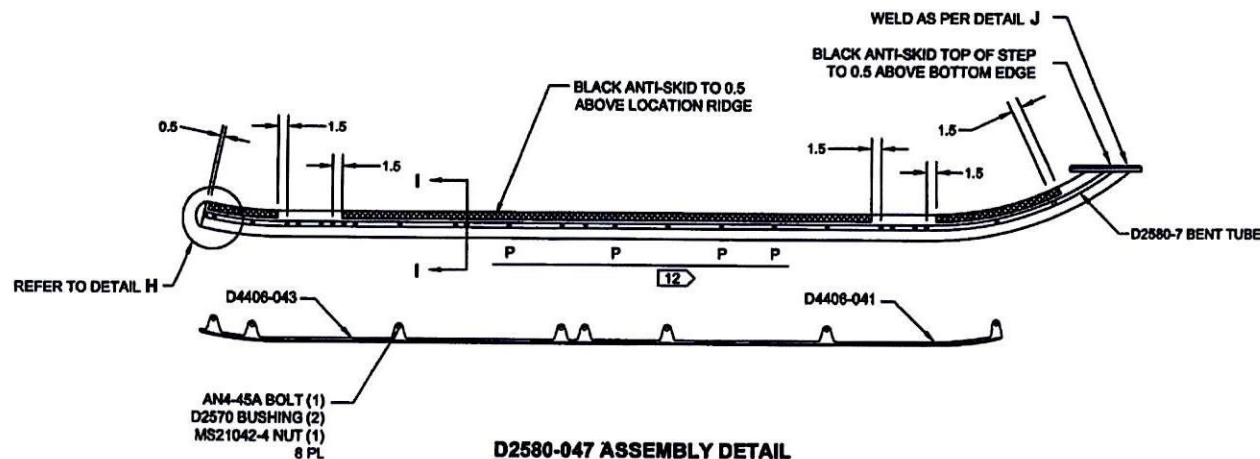


**D2580-5 BENT TUBE**  
(MAKE FROM D2580-101 TUBE)

**RELEASED**

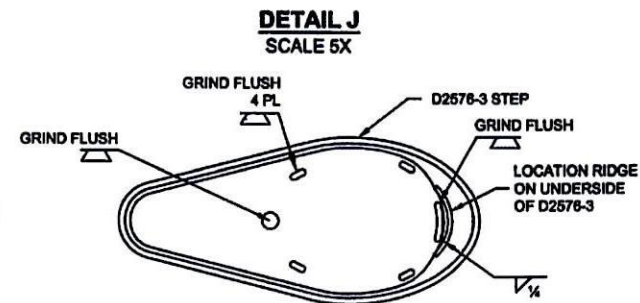
2017 JUL 05 *af*

|            |                    |                                                                                                                                                                                                                                                                                       |              |
|------------|--------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DS                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                              |              |
| DRAWN      | SAD                |                                                                                                                                                                                                                                                                                       |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.                                                                                                                                                                                                                                                                           | REV. H       |
| MFG. APPR. | <i>[Signature]</i> | D2580                                                                                                                                                                                                                                                                                 | SHEET 5 OF 9 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                 | SCALE        |
| DE APPR.   | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                 | NTS          |
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AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

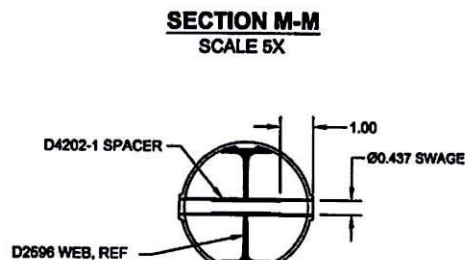
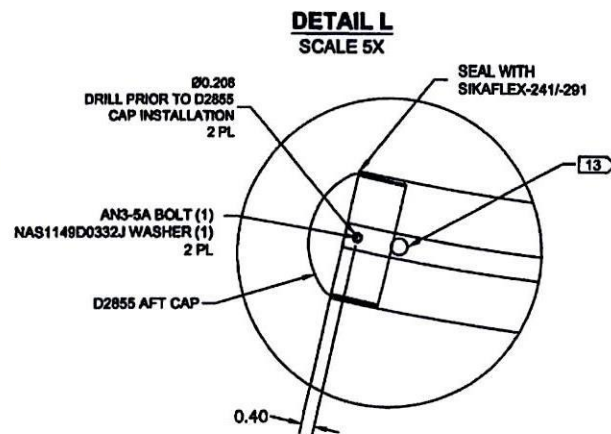
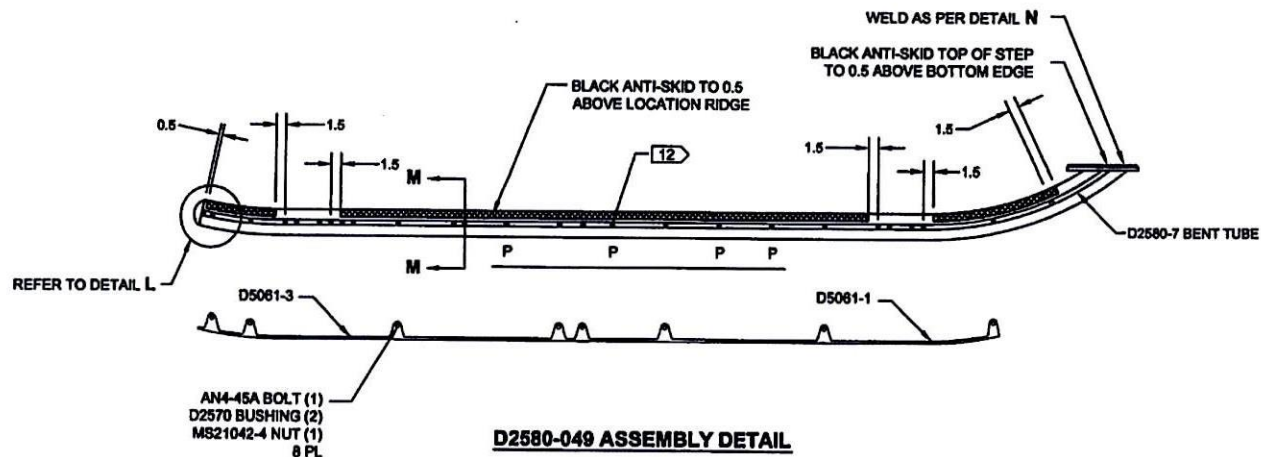


RELEASED

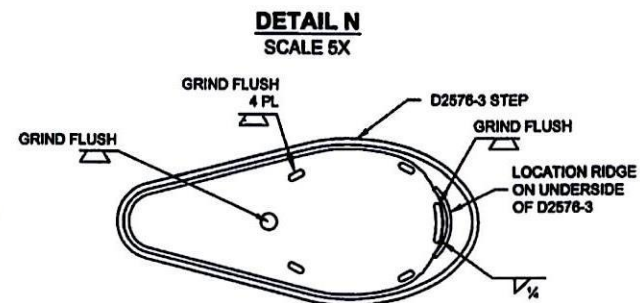
2017 JUL 05

|                                                                                                                                                                                                                               |                    |                                        |              |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                        | DS                 | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                         | SAD                | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                       | <i>[Signature]</i> | DRAWING NO.                            | REV. H       |
| MFG. APPR.                                                                                                                                                                                                                    | <i>[Signature]</i> | D2580                                  | SHEET 6 OF 9 |
| APPROVED                                                                                                                                                                                                                      | <i>[Signature]</i> | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                      | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                  | NTS          |
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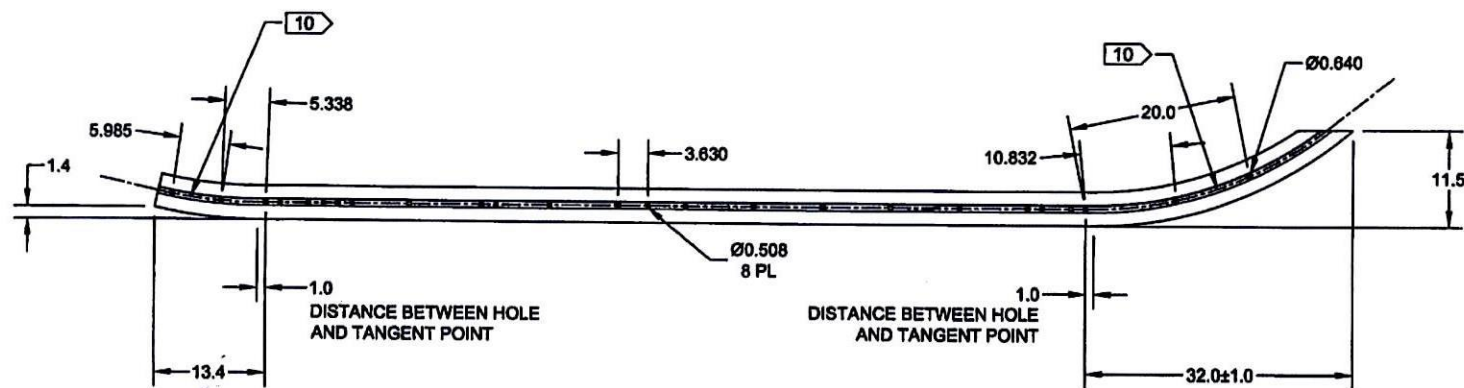


AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. INSERT D4202-1 SPACER (24 PLACES)  
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002  
3. TRIM/GRIND FLUSH PER QSI 002



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2017 JUL 05 *qp*

|                                                                                                                                                                                                                                     |                    |                                        |              |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                              | DS                 | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                               | SAD                | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                             | <i>[Signature]</i> | DRAWING NO.                            | REV. H       |
| MFG. APPR.                                                                                                                                                                                                                          | <i>[Signature]</i> | D2580                                  | SHEET 7 OF 9 |
| APPROVED                                                                                                                                                                                                                            | <i>[Signature]</i> | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                            | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                  | NTS          |
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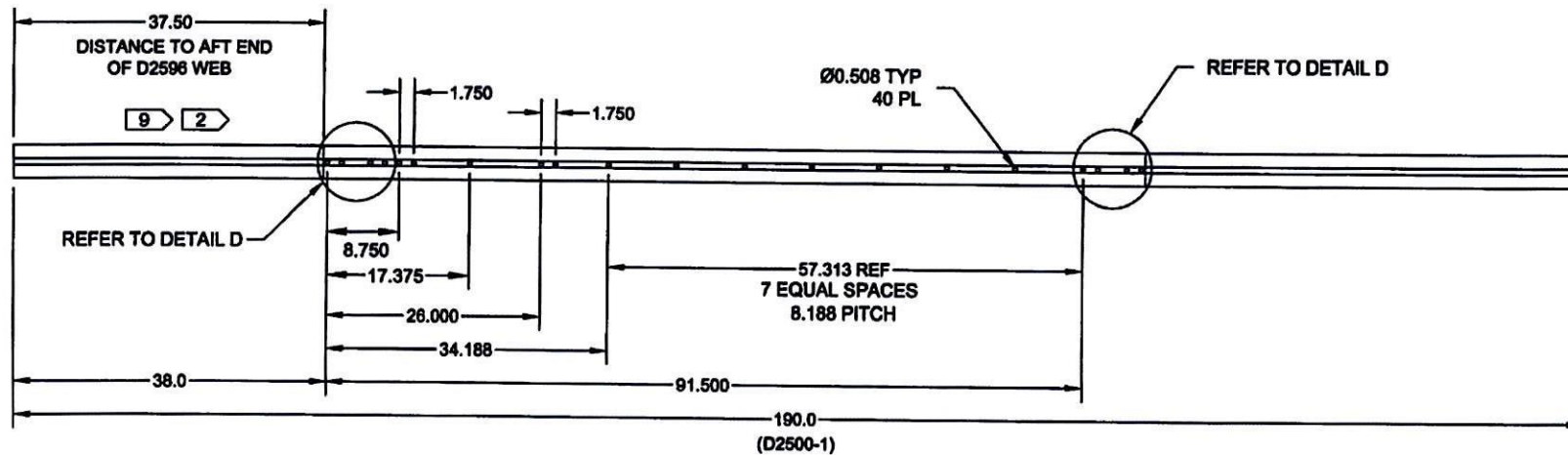


**D2580-7 BENT TUBE**  
(MAKE FROM D2580-101 TUBE)

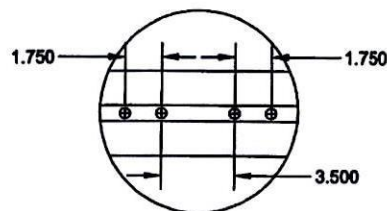
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2017 JUL 05 *ap*

|            |           |                                                                                                                                                                                                                                                                           |              |
|------------|-----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DS        | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                  |              |
| DRAWN      | SAD       |                                                                                                                                                                                                                                                                           |              |
| CHECKED    | <i>MS</i> | DRAWING NO.                                                                                                                                                                                                                                                               | REV. H       |
| MFG. APPR. | <i>MS</i> | D2580                                                                                                                                                                                                                                                                     | SHEET 8 OF 9 |
| APPROVED   | <i>SH</i> | TITLE                                                                                                                                                                                                                                                                     | SCALE        |
| DE APPR.   | <i>SH</i> | 205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                     | NTS          |
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# **D2580-101 TUBE**



**DETAIL D**  
SCALE 5X

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2017 JUL 05

|            |                    |                                                                                                                                                                                                                                                                                                  |              |
|------------|--------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DS                 | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                        |              |
| DRAWN      | SAD                | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                      |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.                                                                                                                                                                                                                                                                                      | REV. H       |
| MFG. APPR. | <i>[Signature]</i> | D2580                                                                                                                                                                                                                                                                                            | SHEET 9 OF 9 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                            | SCALE        |
| DE APPR.   | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                            | NTS          |
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